

Work Order ID 92466

October-30-12 9:20:47 AM

92466

Page 1

Item ID: D2596

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web, 205 Skidtube

Start Date: 30/10/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 13/11/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 12-10-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

| | |
|-------|-------|
| D2596 | Rev D |
|-------|-------|

| | | |
|-----|--|------|
| 100 | | 0.00 |
|-----|--|------|

100

Skid tubes

Skid tubes

Memo

0.00

Skid tubes

1- Cut D2500-3-100 to length: 99.5"
2- Use Jig DT8093 to drill pilot holes #30
3- Open to 0.630" diameter as per Dwg D2596
4- Deburr

1 12/10/30

| | | |
|-----|--|------|
| 110 | | 0.00 |
|-----|--|------|

110

Hand Finish

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Hand Finishing

4 16 12-10-30

| | | |
|-----|--|------|
| 120 | | 0.00 |
|-----|--|------|

120

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

D45
03
89

12-11-1

4

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Accept

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130 Identify as per dwg & Stock Location: **46**

0.00

130

Packaging Memo

0.00

Packaging

DD 12-11-1

140 QC21- Final Inspection - Work Order Release 0.00

140

QC Memo

0.00

Quality Control

12/11/2012

W 12-11-01

Picklist Print

October-30-12 9:20:50 AM

Page 1

Work Order ID: 92466

92466

Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 30/10/2012

Required Date: 13/11/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorporated DEO 9183 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2500-3-100 | | Manufactured | No | | | 100 | Each | 253.0000 | 1 | 4 | | | |
| *D2500-3-100* | | | | | | | | | ** | | | | |
| Ext'n -1" Beam Web 4" | | | | | | | | | | | | | |

(4) B 12/10/30

Location

Loc Qty

Loc Code

LG

253

51957

2

79041

2

84873

6

89110

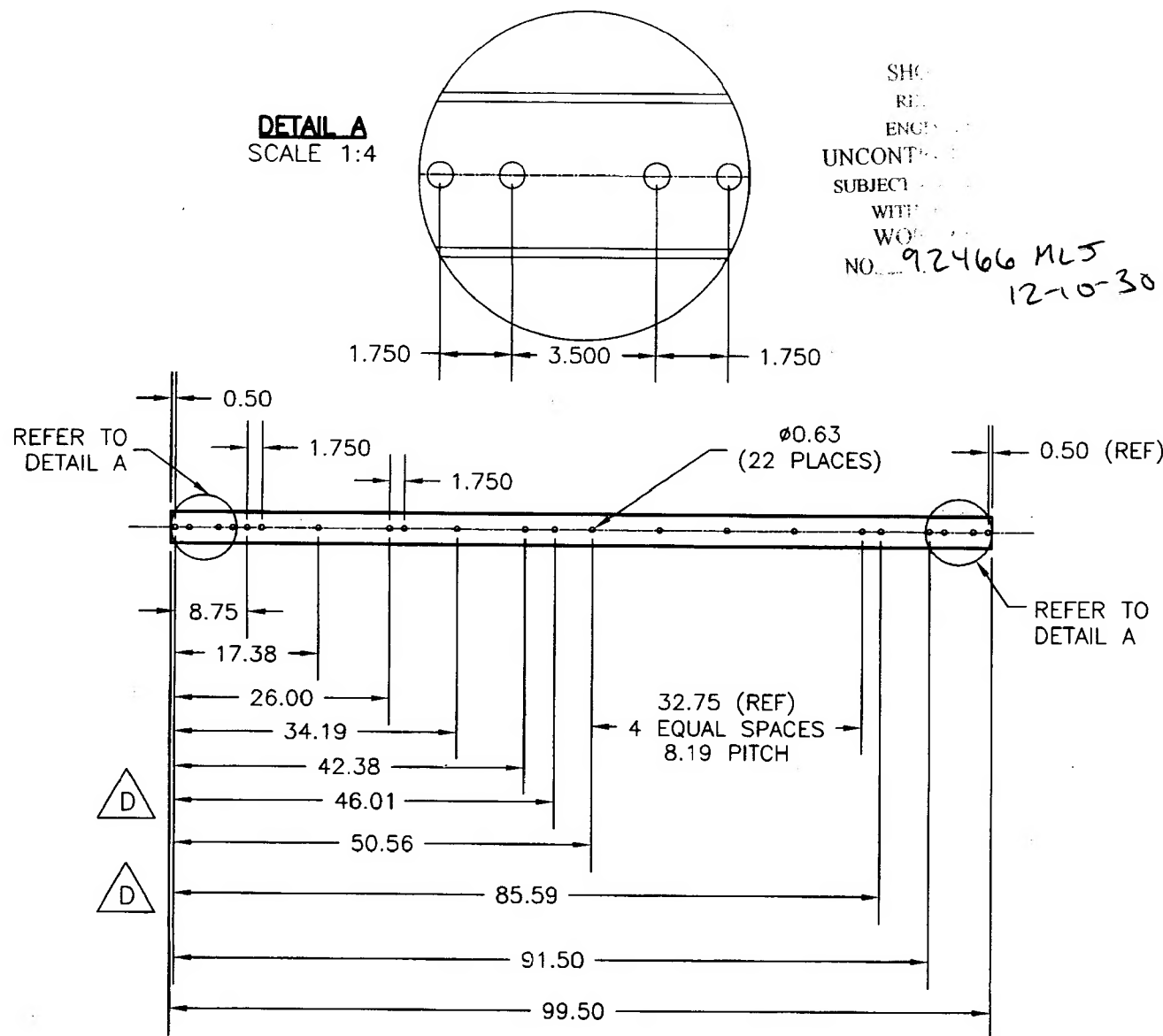
243

DART

RELEASED
07 DEC 68

SHO
RE
ENGE
UNCONT
SUBJECT
WITH
WO
NO. 92466 MJS
12-10-30

DETAIL A
SCALE 1:4



D2596 WEB

- 1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) DEBURR SHARP EDGES 0.010 TO 0.020

| DESIGN | DRAWN BY | DART AEROSPACE LTD | REV. D |
|----------|----------|-----------------------------|--------------|
| 04 | 04 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | SHEET 1 OF 1 |
| 07 | 07 | D2596 | |
| DATE | TITLE | SCALE | |
| 07.04.17 | 205 WEB | 1:20 | |
| A | 96.09.16 | NEW ISSUE | |
| B | 97.07.23 | 0.63 HOLE WAS 0.56 | |
| C | 98.09.14 | INCORPORATED DEO 9097 | |
| D | 07.04.17 | INCORPORATED DEO 9183 | |

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